

Date: Friday, 1/25/2008 10:53:52 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L AFT X-TUBE  
 Job Number : 36978  
 Estimate Number : 10973  
 P.O. Number :  
 This Issue : 1/25/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D206667203  
 First Issue : 1 / 1 Type : LANDING GEAR Drawing Number : D206-667-243 REV B  
 Previous Run : 36382 Drawing Revision :  
 Material :  
 Due Date : 3/10/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 08 01 25  
 Comment : Est Rev. 05.09.01 Add holes for compatibility with Bell  
 Skid tubes KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

08 01 25

2.0 D6004115 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115 Crosstube B34685

Check OD = 2.500"; ID = 1.800"

BG 08-02-27

①

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

BG 08-03-02

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BG 08-07-02

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  | 5/18                        |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Job Number: 36978

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243

Inside of Cuff(Donot engrave on outside of tube)

BC 08-03-02

(1)

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BC 08-03-02

(1)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ML 08/03/03

(1)

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



AWM 8-3-4



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/04

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 8-3-11

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

IL/TR 8-3-18

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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Drawing Name: 206L AFT X-TUBE

Job Number: 36978

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

0603-18 (1)

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243  
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

EL/JD  
8-3-19

AWM  
8-3-20

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 8-3-20

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

05/9/20 (2)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

05/9/20 (2)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Job Number: 36978

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 5967

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

*C208103120 ①*

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

*1/23/20 C*

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

*ET 08-03-24*

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

*ET 08-03-21*

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

*ET 08-03-24 ①*

*ET 08-03-22*

22.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

*34077*

*ET 08-03-22*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



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Drawing Name: 206L AFT X-TUBE

Job Number: 36978

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

36064

25 08-03-22

24.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

105057

25 08-03-22

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

25 08-03-22

26.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

35900

25 08-03-22

27.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1

Support

34063

25 08-03-22

28.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

106627

25 08-03-22

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Drawing Name: 206L AFT X-TUBE

Job Number: 36978

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

RT 08-03-22

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-03-24 (1)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M104679

SP

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M106277

SP

34.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt

M10659 (8K)

M107013 (2X)

35.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

M106242 8/3/2554

(1X)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Drawing Name: 206L AFT X-TUBE

Job Number: 36978

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN5-32A

Bolt

36.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

18 AN960JD516 Washer M106654

8/3/25 SC

(12)

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/03/25 (12)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location: 52

PPP Rev: C

8/3/25 SC

(12)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/26 (1)

Job Completion



C208/03/26

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|                                                   |  |                     |              |
|---------------------------------------------------|--|---------------------|--------------|
| <b>DART AEROSPACE LTD</b>                         |  | <b>Work Order:</b>  | 36978        |
| <b>Description:</b> Crosstube Assembly            |  | <b>Part Number:</b> | D206-667-243 |
| <b>Inspection Dwg:</b> D206-667-243 <b>Rev:</b> B |  | <b>Page 1 of 1</b>  |              |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

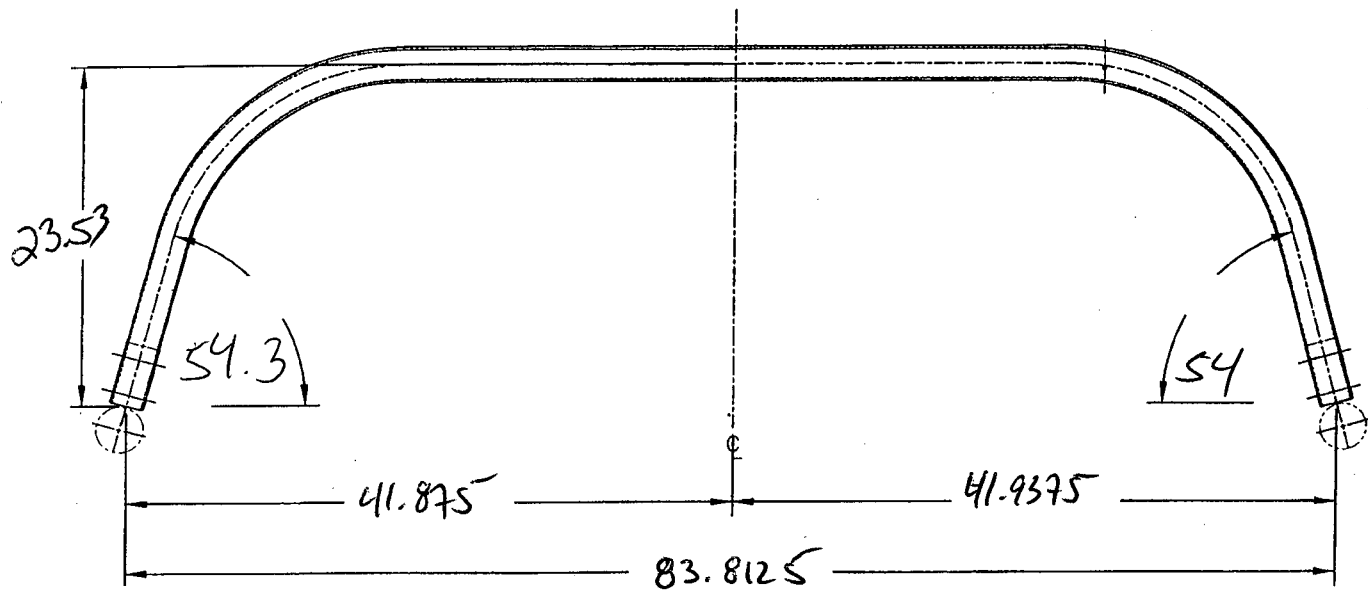
| Inspection Sheet<br>Drawing Dimension | Tolerance   | Actual<br>Dimension | Accept         | Reject | Method of<br>Inspection | Comments |
|---------------------------------------|-------------|---------------------|----------------|--------|-------------------------|----------|
| SIDE A                                | 2.490       | +0.005/-0.000       | 2.492          | ✓      |                         |          |
|                                       | 2.018       | +0.005/-0.000       | 2.022          | ✓      |                         |          |
|                                       | 2.079       | +0.005/-0.000       | 2.083          | ✓      |                         |          |
|                                       | 2.145       | +0.005/-0.000       | 2.149          | ✓      |                         |          |
|                                       | 2.209       | +0.005/-0.000       | 2.213          | ✓      |                         |          |
|                                       | 2.287       | +0.005/-0.000       | 2.291          | ✓      |                         |          |
|                                       | 2.363       | +0.005/-0.000       | 2.365          | ✓      |                         |          |
|                                       | 2.433       | +0.005/-0.000       | 2.436          | ✓      |                         |          |
|                                       | 0.200       | +/-0.010            | .200           | ✓      |                         |          |
|                                       | 0.500 x 30° | +/-0.010            | .500           | ✓      |                         |          |
|                                       | R0.063      | +/-0.010            | .063           | ✓      |                         |          |
|                                       | R0.500      | +/-0.010            | .500           | ✓      |                         |          |
|                                       | 4.438       | +/-0.030            | 4.438          | ✓      |                         |          |
|                                       |             |                     |                |        |                         |          |
|                                       |             |                     |                |        |                         |          |
| SIDE B                                | 104.91      | +/-0.020            | 104.91         | ✓      |                         |          |
|                                       | 2.490       | +0.005/-0.000       | 2.492          | ✓      |                         |          |
|                                       | 2.018       | +0.005/-0.000       | 2.022          | ✓      |                         |          |
|                                       | 2.079       | +0.005/-0.000       | 2.082<br>2.083 | ✓      |                         |          |
|                                       | 2.145       | +0.005/-0.000       | 2.148          | ✓      |                         |          |
|                                       | 2.209       | +0.005/-0.000       | 2.213          | ✓      |                         |          |
|                                       | 2.287       | +0.005/-0.000       | 2.291          | ✓      |                         |          |
|                                       | 2.363       | +0.005/-0.000       | 2.365          | ✓      |                         |          |
|                                       | 2.433       | +0.005/-0.000       | 2.436          | ✓      |                         |          |
|                                       | 0.200       | +/-0.010            | .200           | ✓      |                         |          |
|                                       | 0.500 x 30° | +/-0.010            | .500           | ✓      |                         |          |
|                                       | R0.063      | +/-0.010            | .063           | ✓      |                         |          |
|                                       | R0.500      | +/-0.010            | .500           | ✓      |                         |          |
|                                       | 4.438       | +/-0.030            | 4.438          | ✓      |                         |          |
|                                       |             |                     |                |        |                         |          |

|                     |          |                    |          |                            |     |
|---------------------|----------|--------------------|----------|----------------------------|-----|
| <b>Measured by:</b> | RL       | <b>Audited by:</b> | ML       | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b>        | 08.03.02 | <b>Date:</b>       | 08/03/03 | <b>Date:</b>               | N/A |

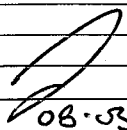
| Rev | Date     | Change                       | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A   | 06.09.01 | New Issue (P/O D206-667-203) | KJ/JLM     |          |

|                                        |  |              |              |
|----------------------------------------|--|--------------|--------------|
| DART AEROSPACE LTD                     |  | Work Order:  | 36978        |
| Description: Crosstube High Aft (206L) |  | Part Number: | D206-667-203 |
| Inspection Dwg: D206-667-243 Rev: B    |  | Page 1 of 1  |              |


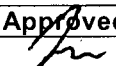
| Required Dimension | Min   | Max   |
|--------------------|-------|-------|
| Height             | 23.46 | 23.58 |
| 1/2 Span           | 41.86 | 41.98 |
| Angle              | 54    | 56    |
| Total Span         | 83.72 | 83.96 |



| Comments |
|----------|
|          |
|          |
|          |
|          |

|                 |                                                                                     |
|-----------------|-------------------------------------------------------------------------------------|
| QC15 Inspection |  |
| Date            |                                                                                     |

08-03-19

| Rev | Date     | Change    | Revised by                                                                                  | Approved                                                                              |
|-----|----------|-----------|---------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| A   | 07.02.06 | New Issue | KJ/JM  |  |





|                  |                  |                                                                     |                        |
|------------------|------------------|---------------------------------------------------------------------|------------------------|
| DESIGN<br>PH     | DRAWN BY<br>PH   | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA                   |                        |
| CHECKED<br># DS  | APPROVED<br># DS | DRAWING NO.<br>D206-667-243                                         | REV. B<br>SHEET 1 OF 3 |
| DATE<br>05.07.26 |                  | TITLE<br>CROSSTUBE ASS'Y (206L HIGH AFT) NTS                        |                        |
| A                | 00.11.17         | NEW ISSUE                                                           |                        |
| B                | 05.07.26         | ADD HOLES AND NUT PLATES FOR<br>COMPATABILITY WITH BHT/AA SKIDTUBES |                        |

RELEASED  
05.07.26 - #

UNDER REVIEW

06.07.10 RH

12 draw detail F

RH

07.06.02

| Qty | Part Number   | Description              |
|-----|---------------|--------------------------|
| X   | D206-667-243  | CROSSTUBE ASSEMBLY       |
| 1   | D6004-115     | CROSSTUBE                |
| 2   | D2856-400-773 | ABRASION STRIP           |
| 2   | D2873-043     | NUT PLATE                |
| 2   | D2873-045     | NUT PLATE                |
| 2   | D2892-1       | SUPPORT                  |
| 14  | MS20601AD4W10 | RIVET (OR NAS9302B-4-10) |
| 4   | MS21920-22    | CLAMP                    |

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH =  $104.91 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

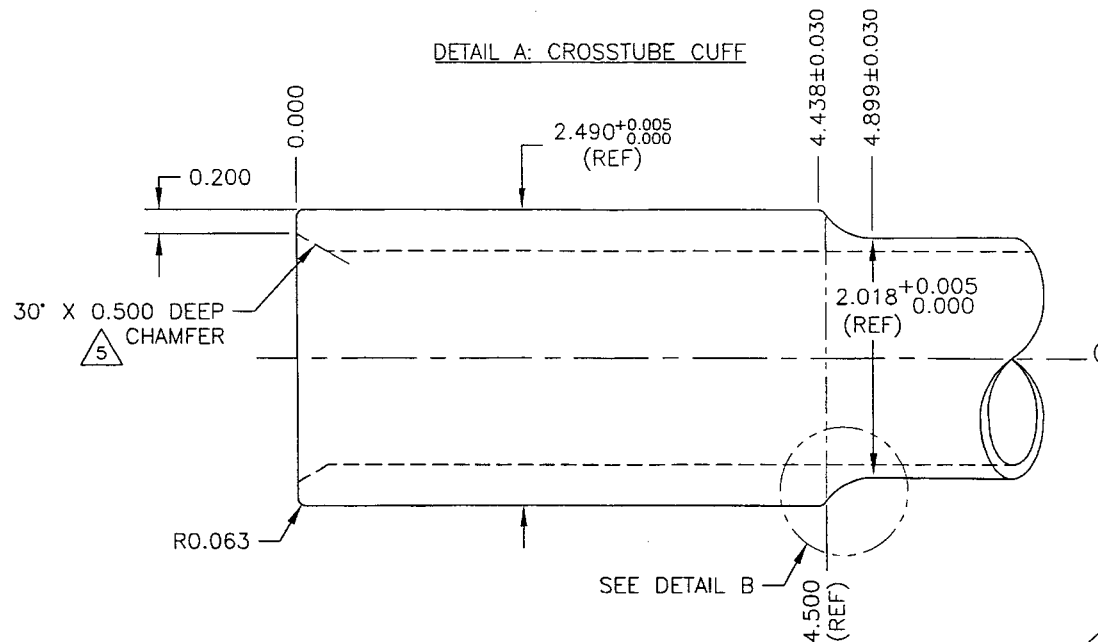
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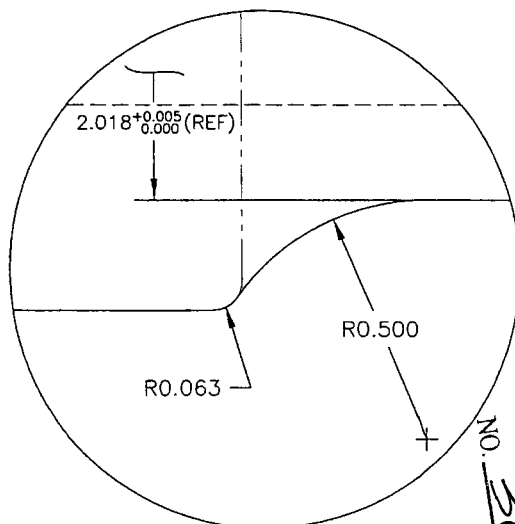
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# DETAIL A: CROSSTUBE CUFF

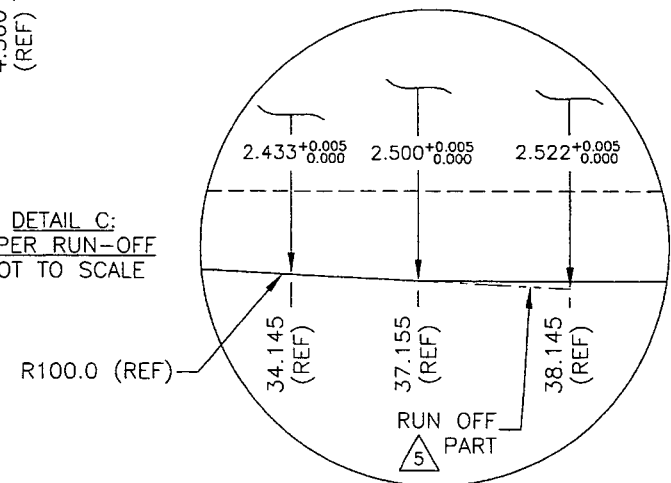


05.07.26 PH  
 UNDER REVIEW  
 06.03.06 PH  
 Re-draw detail F  
 PH 07.05.02



DETAIL B: CUFF  
 TRANSITION  
 SCALE 4:1

DETAIL C:  
 TAPER RUN-OFF  
 NOT TO SCALE



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|                  |                                          |                             |                                                 |
|------------------|------------------------------------------|-----------------------------|-------------------------------------------------|
| DESIGN<br>PH     | DRAWN BY<br>PH                           | <b>DART</b>                 | DART AEROSPACE LTD.<br>MARKHAM, ONTARIO, CANADA |
| CHECKED<br>DS    | APPROVED<br>DS                           | DRAWING NO.<br>D206-667-243 | REV. B<br>SHEET 3 OF 3                          |
| DATE<br>05.07.26 | TITLE<br>CROSSTUBE ASS'Y (206L HIGH AFT) | SCALE<br>1:1                |                                                 |



## LIQUID PENETRANT TEST REPORT

P - 1260 1

PAGE 1 OF 1

|                  |                                      |                 |                   |           |                                                         |
|------------------|--------------------------------------|-----------------|-------------------|-----------|---------------------------------------------------------|
| CLIENT           | DART AEROSPACE                       | DATE            | MAR 20 2008       | TIME      | AM <input type="checkbox"/> PM <input type="checkbox"/> |
| ATTENTION        | LINDA LACELLE                        | ACUREN JOB No.  | 188 08 1260       |           |                                                         |
| ADDRESS          | 1270 ABERDEEN ST<br>HAWKESBURY, ONT. | PO/WO No.       |                   |           |                                                         |
|                  |                                      | WORK LOCATION   | HAWKESBURY        |           |                                                         |
|                  |                                      | ACCEPTANCE STD. | ASTM 1417/QSI-038 | REV./DATE | 2005                                                    |
| PROJECT          | 206L FWD/AFT X TUBES, 407 FWD X TUBE |                 |                   |           |                                                         |
| ITEM(S) EXAMINED | JOB #S 206L-36972,975,978. 407-37002 |                 |                   |           |                                                         |

|                 |                                                                                  |           |                        |           |
|-----------------|----------------------------------------------------------------------------------|-----------|------------------------|-----------|
| JOB DESCRIPTION | PROCEDURE No. LT-0002                                                            | REV./DATE | TECHNIQUE No. LT-TECH2 | REV./DATE |
| PART No.        | D206667108/D206667203/D407667105                                                 | MATERIAL  | ALODINED ALUM.         | THICKNESS |
| SCOPE           | WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE |           |                        |           |

## TEST DETAILS

|                       |                                                 |                                  |                                                |                                                                |                                          |
|-----------------------|-------------------------------------------------|----------------------------------|------------------------------------------------|----------------------------------------------------------------|------------------------------------------|
| METHOD                | <input checked="" type="checkbox"/> FLUORESCENT | <input type="checkbox"/> VISIBLE | <input checked="" type="checkbox"/> WATER WASH | <input type="checkbox"/> SOLVENT REMOVABLE                     | <input type="checkbox"/> POST EMULSIFIED |
| FAMILY BRAND          | MAGNAFLUX                                       |                                  | BLACK LGHT8171                                 | <input type="checkbox"/> OUTPUT > 1000 $\mu$ W/cm <sup>2</sup> | <input type="checkbox"/> AMBIENT < 2 fc  |
| PENETRANTZL67         | MINIMUM DWELL TIME                              | 45 MIN.                          | LIGHTING EQUIP.                                | <input type="checkbox"/> FLASHLIGHT                            | <input type="checkbox"/> TROUBLELIGHT    |
| PENETRANT REMOVER H2O | MINIMUM DRY TIME                                | >10 MIN.                         | OTHER                                          | CAL FEB 12 08                                                  |                                          |
| DEVELOPER SKDS2       | MINIMUM DWELL TIME                              | 10 MIN.                          | LIGHT METER S/N                                | CAL DUE DATE                                                   |                                          |
| DEVELOPER TYPE        | <input checked="" type="checkbox"/> NON AQUEOUS | <input type="checkbox"/> AQUEOUS | <input type="checkbox"/> DRY                   |                                                                |                                          |

## TEST SURFACE

|                     |                                       |                                                  |                                                  |                                       |                                                      |
|---------------------|---------------------------------------|--------------------------------------------------|--------------------------------------------------|---------------------------------------|------------------------------------------------------|
| SURFACE CONDITION   | <input type="checkbox"/> AS GROUND    | <input type="checkbox"/> AS WELDED               | <input type="checkbox"/> MACHINED                | <input type="checkbox"/> SHOT BLASTED | <input checked="" type="checkbox"/> CLEAN BARE METAL |
| SURFACE TEMPERATURE | <input type="checkbox"/> < -4°C/ 20°F | <input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F | <input type="checkbox"/> 10°C/50°F TO 52°C/125°F | <input type="checkbox"/> > 52°C/125°F |                                                      |

RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION

CARRIED OUT ON 100% EXTERNAL

SURFACE ON:

206 FWD X TUBE JOB# 36972, 36975.

206 AFT X TUBE JOB#: 36978.

407 FWD X TUBE JOB#: 37002.

RESULTS: NO INDICATION OF DEFECTS.

ITEMS ACCEPTABLE TO STANDARD

## Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

## Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

|                         |                            |                     |            |           |
|-------------------------|----------------------------|---------------------|------------|-----------|
| CLIENT REPRESENTATIVE   | SIGNATURE                  | DTR # E21522        |            |           |
| TECHNICIAN (SIGNATURE): |                            | REPORT REVIEWED BY: |            |           |
| NAME (PRINT):           | JASON HEWETT               | NAME INITIALS       |            |           |
|                         | 1 <sup>ST</sup> TECHNICIAN |                     |            |           |
| CGSB LEVEL              | 2                          | SNT LEVEL           | CGSB LEVEL | SNT LEVEL |
| CGSB REG. No            | 6156                       | CGSB REG. No        |            |           |

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

Date: Friday, 1/25/2008 10:53:52 AM  
 User: Kim Johnston

## Process Sheet

|                       |                                                                            |                  |                             |
|-----------------------|----------------------------------------------------------------------------|------------------|-----------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services                                      | Drawing Name     | : 206L AFT X-TUBE           |
| Job Number            | : 36978                                                                    |                  |                             |
| Estimate Number       | : 10973                                                                    |                  |                             |
| P.O. Number           | :                                                                          | Part Number      | : D206667203                |
| This Issue            | : 1/25/2008 S.O. No. :                                                     | Drawing Number   | : D206-667-243 REVB         |
| Prsht Rev.            | : NC                                                                       | Project Number   | : N/A                       |
| First Issue           | : 1/1 Type : LANDING GEAR                                                  | Drawing Revision | :                           |
| Previous Run          | : 36382                                                                    | Material         | :                           |
| Written By            | :                                                                          | Due Date         | : 3/10/2008 Qty: 1 Um: Each |
| Checked & Approved By | : <u>08 01 25</u>                                                          |                  |                             |
| Comment               | : Est Rev. 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM |                  |                             |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |    |                  |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL  
 Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

08 02 28

|     |          |                    |
|-----|----------|--------------------|
| 2.0 | D6004115 | Crosstube material |
|-----|----------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Pick:  
 Qty Part number Description Batch  
 1 D6004-115 Crosstube  
 Check OD = 2.500"; ID = 1.800"

|     |            |                            |
|-----|------------|----------------------------|
| 3.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

REFERENCE ONLY

|     |     |                              |
|-----|-----|------------------------------|
| 4.0 | QC1 | INSPECT ALL DIM TO DIM SHEET |
|-----|-----|------------------------------|



Comment: INSPECT ALL DIM TO DIM SHEET